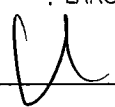


Date: Wednesday, 21/11/2007 3:18:53 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HELI-ACCESS STEP RH (FOLDING)
Job Number	: 35957		
Estimate Number	: 12568		
P.O. Number	: N/A	Part Number	: D412630034
This Issue	: 21/11/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: IIN D412-630
First Issue	: N/A	Project Number	: N/A
Previous Run	: 35798	Drawing Revision	: L
Written By	: 	Material	: N/A
Checked & Approved By	: _____	Due Date	: 23/11/2007
Comment	Est. Rev:A New Issue 06-11-08 JLM est rev B ecn1019, added D2807-041 EC verified by:DD		

Qty: 1 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL
 Photocopy bluefile & create labels per PPP D412-630-034 CHG003

Handwritten: 7/11/23

2.0	D2012107	Clevis
-----	----------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Clevis

Pick:

Qty	Part Number	Description
1	D2012-107	Clevis

Batch

Handwritten: 1333585

Handwritten: SP

3.0	D2803042	Bracket Assembly
-----	----------	------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket Assembly

Pick:

Qty	Part Number	Description
1	D2803-042	Bracket Assembly RH

Batch

Handwritten: 1333589

Handwritten: SP

4.0	D2804042	Bracket Assembly
-----	----------	------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket Assembly

Pick:

Qty	Part Number	Description
1	D2804-042	Bracket Assembly RH

Batch

Handwritten: B34018

Handwritten: 7/11/2150 @

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 21/11/2007 3:18:53 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 35957

Part Number: D412630034

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2807041

GAS SPRING ASSEMBLY



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Support Prop

Batch: B35961

X

SP
7/11/23

6.0

D2813

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Pick:

Qty Part Number

Description

Batch

2 D2813

Washer

129396

* SO

7.0

D3562042

STEP ASSEMBLY, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Step Weldment LH

Pick:

Qty Part Number

Description

Batch

1 D3562-042

Step Weldment RH

B35263

SP

8.0

D33951

Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bushing

Pick:

Qty Part Number

Description

Batch

4 D3395-1

Bushing

1733578

SO

9.0

AN3C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

BOLT

Pick:

Qty Part Number

Description

Batch

2 AN3C21A

Bolt

1101989, 7/11/21 SP (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 21/11/2007 3:18:53 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 35957

Part Number: D412630034

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

AN8C16

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description
2	AN8C16	Bolt

Batch

M102736

SG

11.0

AN310C8

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description
2	AN310C8	Nut

Batch

M104679

SG

12.0

MS24665302

Cotter Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Cotter Pin

Pick:

Qty	Part Number	Description
2	MS24665-302	Cotter Pin (or AN380C3-4)

Batch

M16941

SG

13.0

NAS1515H3

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
6	NAS1515H3	Washer

Batch

M105169

SG

14.0

NAS1515H5L

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

WASHER

Pick:

Qty	Part Number	Description
4	NAS1515H5L	Washer

Batch

M105792

M11/12 SG @

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 21/11/2007 3:18:53 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 35957

Part Number: D412630034

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

NAS1515H8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
4	NAS1515H8	Washer

Batch

M104871

SP

16.0

MS210433

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description
4	MS21043-3	Nut

Batch

M105192

SP

17.0

MS24693C280

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

Pick:

Qty	Part Number	Description
2	MS24693-C280	Screw (or MS24694-C565)

Batch

M101390

7/11/21 12 SP

18.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D412-630 p.14

Coat all hardware with LPS3 rust inhibitor

A/R LPS3 batch: *m104929*

COAT exposed HARDWARE WITH LPS PROCYON .

A/R LPS PROCYON BATCH: *m17045*

MF 07-12-23

1

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7/11/21 12 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 21/11/2007 3:18:53 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 35957

Part Number: D412630034

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

21.0

D28061

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bushing

Pick: Packing Kit

Qty	Part Number	Description
2	D2806-1	Bushing

Batch

133590

50

22.0

D28063

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bushing

Pick: Packing Kit

Qty	Part Number	Description
2	D2806-3	Bushing

Batch

132984

50

23.0

D28105

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Strut

Pick: Packing Kit

Qty	Part Number	Description
1	D2810-5	Strut

Batch

132775

50

24.0

D33961

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer

Pick: Packing Kit

Qty	Part Number	Description
2	D3396-1	Spacer

Batch

1329496

50

25.0

AN4C6A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description
-----	-------------	-------------

Batch

1105426

7/11/21 50 (1)

Date: Wednesday, 21/11/2007 3:18:53 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 35957

Part Number: D412630034

Job Number:



Seq. #:

Machine Or Operation:

Description :

1 AN4C6A Bolt

26.0

AN4C10A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

1 AN4C10A

Bolt

~~M101189~~

SC

27.0

AN4C15A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

2 AN4C15A

Bolt

~~M103915~~

SC

28.0

AN44C7A

Eyebolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Eyebolt

Pick: Packing Kit

Qty Part Number

Description

Batch

1 AN44-C7A

Eyebolt

~~M101711~~

M101711

SC

29.0

AN5C15A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

2 AN5C15A

Bolt

~~M101291~~

SC

30.0

NAS1515H4

Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)

Washer

Pick: Packing Kit

Qty Part Number

Description

Batch

7 NAS1515H4

Washer

~~M104715~~

7/11/21 SC (2)

Date: Wednesday, 21/11/2007 3:18:53 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 35957

Part Number: D412630034

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

NAS1515H5

Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)

Washer

Pick: Packing Kit

Qty	Part Number	Description
7	NAS1515H5	Washer

Batch

M105792

SD

32.0

MS210434

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Pick: Packing Kit

Qty	Part Number	Description
4	MS21043-4	Nut

Batch

M105793

SD

33.0

MS210435

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Nut

Pick: Packing Kit

Qty	Part Number	Description
3	MS21043-5	Nut

Batch

M105430

7/11/21 SD (1x)

34.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

6 7/11/23

35.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-034

Location:

PPP Rev:

A

7/11/23

SD

(1x)

Handwritten signature

36.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

7/11/23

Job Completion



7/11/23

D412-630-033/-034 Heli-Access-Step™ Installation

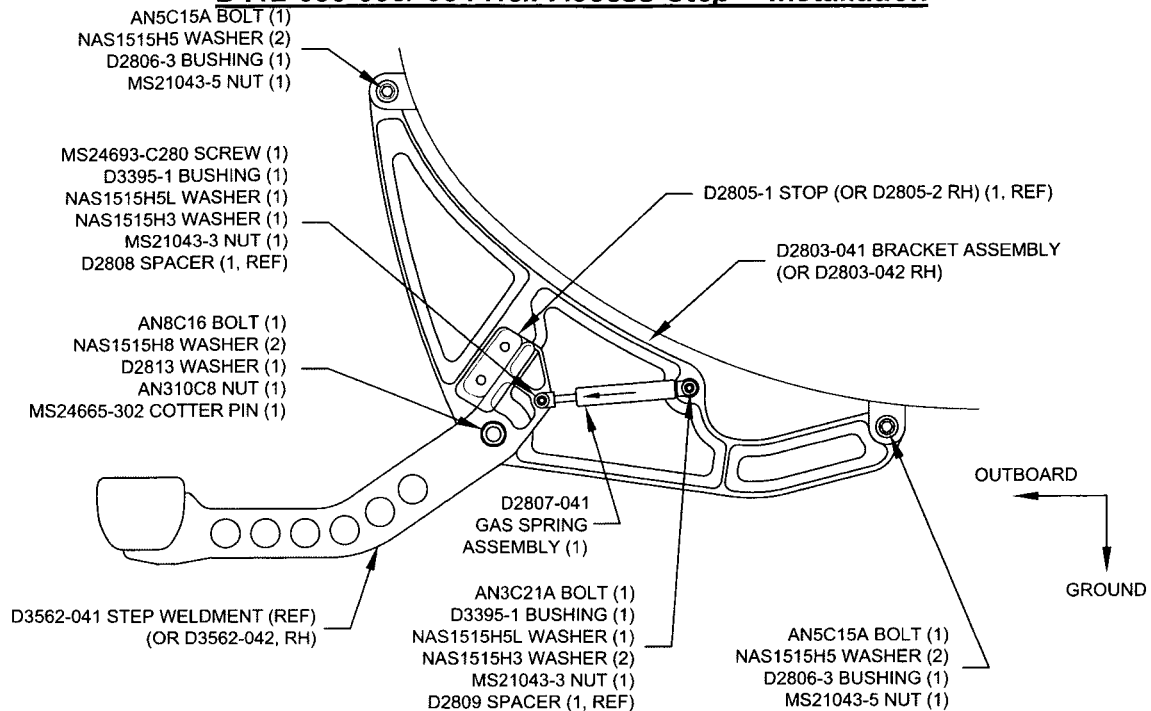


FIGURE 14 – STA 84.29 for D412-630-033/-034 Heli-Access-Step™ Installation (View rotated 90° CW)

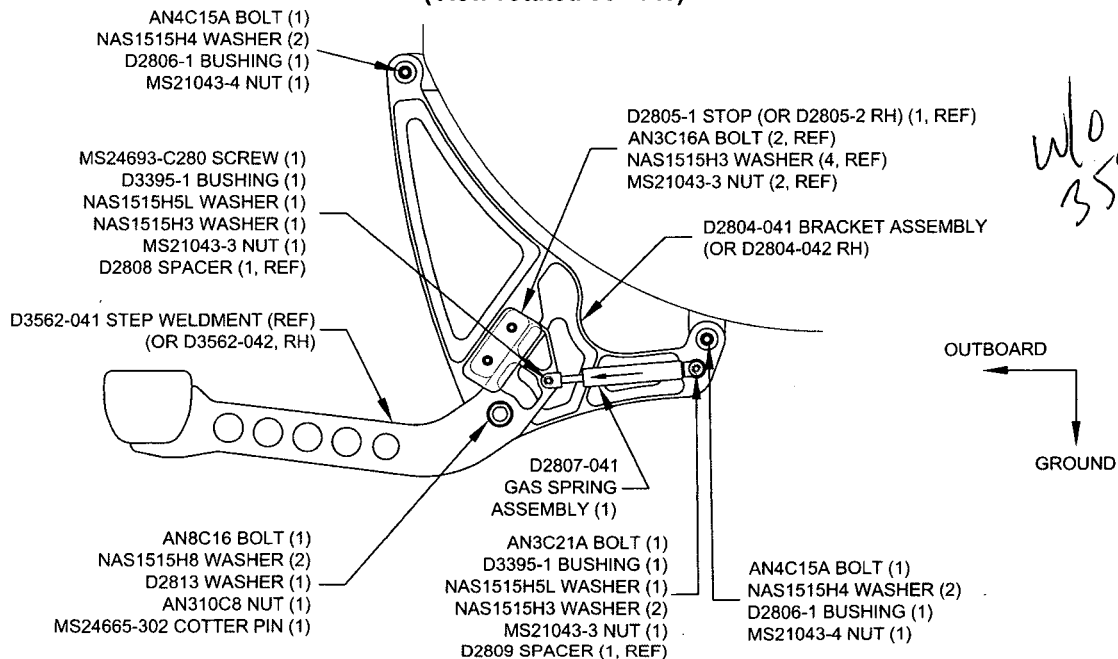


FIGURE 15 – STA 155.06 for D412-630-033/-034 Heli-Access-Step™ Installation (View rotated 90° CW)

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Revision: L
Date: 07.09.30

Date: Wednesday, 11/21/2007 3:18:16 PM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	HELI-ACCESS STEP RH (FOLDING)
Job Number :	35957		
Estimate Number :	12568		
P.O. Number :		Part Number :	D412630034
This Issue :	11/21/2007 S.O. No. :	Drawing Number :	IIN D412-630
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	// Type : LARGE FAB ASSY	Drawing Revision :	L
Previous Run :	35798	Material :	
Written By :	<u>W</u>	Due Date :	11/23/2007 Qty: 1 Um: Each
Checked & Approved By :			
Comment :	Est. Rev:A New Issue 06-11-08 JLM est rev B ecn1019, added D2807-041 EC verified by:DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Photocopy bluefile & create labels per PPP D412-630-034 CHG003

07.11.21 *g*

2.0	D2012107	Clevis
-----	----------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Clevis

Pick:

Qty	Part Number	Description	Batch
1	D2012-107	Clevis	

REFERENCE ONLY

3.0	D2803042	Bracket Assembly
-----	----------	------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket Assembly

Pick:

Qty	Part Number	Description	Batch
1	D2803-042	Bracket Assembly RH	

4.0	D2804042	Bracket Assembly
-----	----------	------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket Assembly

Pick:

Qty	Part Number	Description	Batch
1	D2804-042	Bracket Assembly RH	

Job Completion

